

Work Order ID 86256

86256

Page 1

June-25-12 10:51:41 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH

Stop ***NS2***

Start Date: 25/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/25

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

100

DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006



for MLJ 12-7-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

BE 12/07/11

BE 12/07/11

BB

12/07/11

BB

12/07/11

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch: *M122130 BE 12/07/11*

12-Grind welds flush as per Dwg D2750 *BE 12/07/11*

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

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Stop *NS2*

Start Date: 25/06/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/07/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150 QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 122130

exp. date: 12/4/12

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch: M122130

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

JB 12/07/16

3 BE 12/07/18

JB 12/07/18

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Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

dwg D2750

12-Deburr holes

BB 2/07/18

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

DAS
16
9.83 17/07/13

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

DAS
16
9.83 12/4/13

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Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 0 127 23.

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

200

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

2-30
3200 F
3-00

210 QC3- Inspect Part Finish

0.00

210

QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

m-f
12/07/24

1 RH 2 24 12/07/24

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N900040100Setup Start ***NS1***

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Stop ***NS2***Start Date: 25/06/2012 Start Qty: 1.00 ***1***

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Required Date: 10/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Spray inside of tube with "LPS-3" batch: <u>11/11</u>								
	4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>122130</u> EXP DATE: <u>14/07</u>								
	5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>110340</u>								
	6-Coat all exposed fasteners with "LPS Procyon" batch: <u>114596</u>								

1 Rlt 2 20 12/07/24

3

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Stop ***NR2***Sequence ID/
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Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Rev I

IX

SP
12-7-26

Packaging

Package as per PPP D350-636-012

280

0.00

280

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

12/7/27 DJ

Quality Control

UMF 12-07-26

Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 86256

86256

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured No

110

Each

23.0000

1

1

D2600-3-BENT

Extrusion Bent

**

Location

Loc Qty

Loc Code

LG

23

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

83305

1

83442

7

D2744

Manufactured No

110

Each

68.0000

1

1

D2744

Cap

**

Location

Loc Qty

Loc Code

LG002

68

62715

1

83412

29

85506

38

BE 12/07/11
B 86330 x1

BE 12/07/11

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D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

11.0000

1

D2739

3501 Beam

**

1 BE 12/07/12

Location

85487

Loc Qty

Loc Code

LG

11

72155

1

81508

1

83447

3

83448

4

83548

2

D2743

Manufactured No

160

Each

240.0000

8

D2743

Crossbolt Spacer

**

8 BE 12/07/17

Location

Loc Qty

Loc Code

LG

166

81965

39

83262

127

LG001

74

67766

4

68251

3

73403

64

74445

1

79517

2

D3490-3

Manufactured No

160

Each

102.0000

4

D3490-3

Cross Bolt Spacer

**

4 BE 12/07/17

Location

Loc Qty

Loc Code

LG001

102

83313

42

85420

60

June-25-12 10:51:45 AM

Shop Packet Print

Page 2

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Parent Item Name: Skidtube RH

86256

D350-636-012

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

111.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE 12/07/17

Location

Loc Qty

Loc Code

LG

88

81976

2

85419

86

LG001

23

62450

2

74875

4

77042

3

83269

14

D3631-1

Manufactured No

230

Each

283.0000

8

8

D3631-1

Washer

**

8

(2P)

12/07/24

Location

Loc Qty

Loc Code

FG

268

81874

2

83588 ✓

266

ST072

15

68062

2

75548

13

D3791-1

Manufactured No

230

Each

26.0000

1

1

D3791-1

Wearplate

**

1

(2P)

12/07/24

Location

Loc Qty

Loc Code

FP002

26

62239

2

83392 ✓

12

83902

12

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 4

Work Order ID: 86256

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

86256

D350-636-012

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each

28.0000 1 1

D3793-3

Wearshoe

**

1

DP

12/07/24

Location

Loc Qty

Loc Code

FP001

28

83394

16

83901 ✓

12

MS21043-6

Purchased No

230 Each

586.0000 4 4

MS21043-6

NUT

**

4

DP

12/07/24

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

566

117887

2

118384 ✓

64

120308

500

D3794-1

Manufactured No

230 Each

24.0000 1 1

D3794-1

Gasket

**

1

DP

12/07/24

Location

Loc Qty

Loc Code

FP

4

82167

4

FP002

20

83395 ✓

20

June-25-12 10:51:45 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 86256

86256

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased No

230 Each

416.0000 8 8

NAS1611-010

O-RING

**

8

JP

12/07/24

Location

Loc Qty

Loc Code

FP001

416

110915

14

117460

8

118077

1

118612

3

119438

47

121259

2

121584

2

121723

39

122151✓

300

D2741

Manufactured No

250 Each

43.0000 1 1

D2741

Blade, 350 Skidtube

**

JB

12/07/25

Location

Loc Qty

Loc Code

ST

-10

ST466

53

71856

1

79516

3

83135

39

83135

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 86256

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

86256

D350-636-012

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

312.0000

4

4

**

4

2P

12/07/24

*NAS1515H3I *

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

272

118686

3

119438

1

120360

11

121550

57

122151

200

NAS1611-013

Purchased

No

230

Each

317.0000

8

8

**

7

2P

12/07/24

NAS1611-013

O-RING

Location

Loc Qty

Loc Code

FP001

317

116582

5

117291

2

117887

53

119623

36

121584

5

121825

174

121826

42

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 86256

86256

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

335.0000

4

4

AN3C6A

BOLT

**

4

SP

12/07/24

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

334

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693

118

121682 ✓

124

NAS1149C0832R

Purchased

No

230

Each

250.0000

1

1

NAS1149C0832R

WASHER

**

1

SP

12/07/24

Location

Loc Qty

Loc Code

ST297

250

114915 ✓

250

D3536-25

Manufactured

No

230

Each

26.0000

1

1

D3536-25

Gasket

**

1

SP

12/07/24

Location

Loc Qty

Loc Code

FP

26

83391

10

83900 ✓

16

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86256

86256

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

21.0000

1

1

D3794-3

Gasket

**

1 2P 12/07/24

Location

Loc Qty

Loc Code

FP

19

83396 ✓

19

FP002

2

74530

2

AN3C5A

Purchased

No

230

Each

1,688.000

34

34

AN3C5A

Bolt

**

34 2P 12/07/24

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1681

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255 ✓

500

121444

68

121708

500

122141

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86256

86256

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

82.0000

3

3

D3537-1

Wearpad

**

3

DP

12/07/24

Location

Loc Qty

Loc Code

FP002

85457✓

82

81362

3

83254

1

83255

3

83256

25

85458

50

D3535-25

Manufactured No

230

Each

32.0000

1

1

D3535-25

Wearshoe

**

1

DP

12/07/24

Location

Loc Qty

Loc Code

FP001

32

62233

1

81357

1

83387

17

83899✓

13

D3492-3

Manufactured No

230

Each

139.0000

8

8

D3492-3

Plug

**

8

DP

12/07/24

Location

Loc Qty

Loc Code

FP-A

139

81967

5

83099

12

83529

122

85461✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 86256

86256

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

~~*~~ NAS1149C0332
R

Purchased

No

230

Each

21.0000

38

38

*AN960C10I *

washer

122063✓

**

38

28

12/07/24

Location

Loc Qty

Loc Code

ST

21

107534

21

D3488-042

Manufactured

No

230

Each

16.0000

1

1

D3488-042

Blade Fitting Assembly, RH

**

1

28

12/07/24

Location

Loc Qty

Loc Code

FP

-1

83417

11

FP002

17

85734

5

ALS4-1032-225

Purchased

No

230

Each

492.0000

38

38

AI S4-1032-225

Insert

**

38

28

12/07/24

Location

Loc Qty

Loc Code

ST281

469

108696

146

110768

62

118386

55

118966

68

121269

138

ST282

23

120410

10

120451

13

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Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 86256

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

86256

D350-636-012

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

205.0000

8

8

D3492-1

Plug

**

8

DP

12/07/24

Location

Loc Qty

Loc Code

FP002

198

69531

8

74444

2

76235

4

83259 ✓

184

FP-A

7

83098

7

D3793-1

Manufactured No

230

Each

26.0000

1

1

D3793-1

Wearshoe

**

1

DP

12/07/24

Location

Loc Qty

Loc Code

FP001

26

82171

2

83393 ✓

11

83903

13

AN8C35A

Purchased No

230

Each

61.0000

1

1

AN8C35A

BOLT

**

1

DP

12/07/24

Location

Loc Qty

Loc Code

FP002

60

115960

1

118286

9

121275 ✓

50

ST346

1

114442

0

115188

0

115960

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 86256

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

86256

D350-636-012

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

108.0000

1

1

MS21083C8

NUT

**

1  12/07/24

Location

Loc Qty

Loc Code

304

53

121185 ✓

22

121349

31

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST321

50

122141

50

D2745

Manufactured

No

230

Each

258.0000


8

8

D2745

Bushing

**

8  12/07/24

Location

Loc Qty

Loc Code

FP

206

79518

6

85416

200

FP001

52

69529

1

76142

1

83260

50

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Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 13

Work Order ID: 86256

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

86256

D350-636-012

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

58.0000

4

4

AN6C44A

BOLT

**

4

12/07/24

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

56

121013

11

121440 ✓

45

D3532-1

Manufactured

No

250

Each

28.0000

2

2

D3532-1

Spacer

**

2

12/07/25

Location

Loc Qty

Loc Code

ST053

28

82041

3

83319

25

MS21083C8

Purchased

No

250

Each

108.0000

2

2

MS21083C8

NUT

**

2

12/07/25

Location

Loc Qty

Loc Code

304

53

121185

22

121349

31

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST321

50

122141

50

122141

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Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 14

Work Order ID: 86256

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

86256

D350-636-012

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

235.0000

2

2

**

NAS1149D0863.I

WASHER

Location

Loc Qty

Loc Code

ST298

235

118078

34

119307

1

120308

100

121556

100

120308

D3493-1

Manufactured

No

250

Each

111.0000

2

2

**

D3493-1

Washer

Location

Loc Qty

Loc Code

ST050

111

77573

1

82023

10

83097

100

83097

AN8C21A

Purchased

No

250

Each

41.0000

2

2

**

AN8C21A

BOLT

Location

Loc Qty

Loc Code

ST343

41

118758

3

121275

38

121275

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86256-ML5

12/06/25

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS. ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F	
TITLE 350 SKIDTUBE ASSEMBLY		SCALE	
		NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

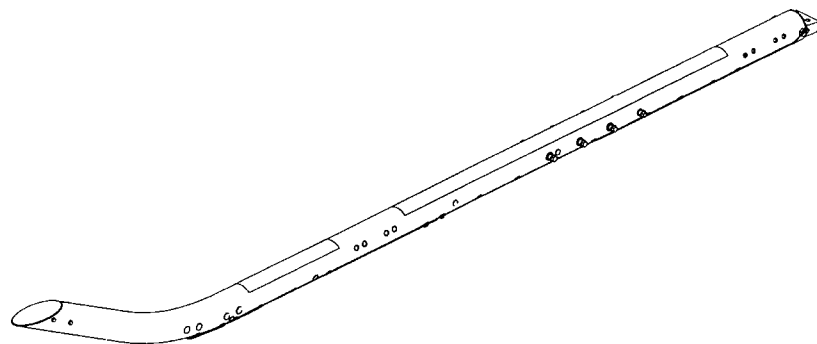
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

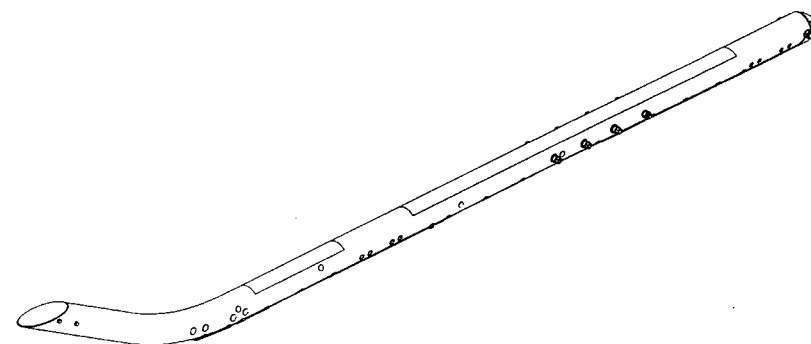
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

06256



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
28 JUN 77

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	ME	D2750	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	350 SKIDTUBE ASSEMBLY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

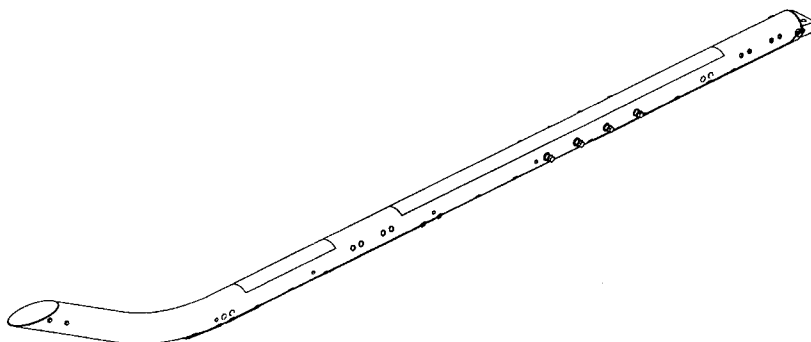
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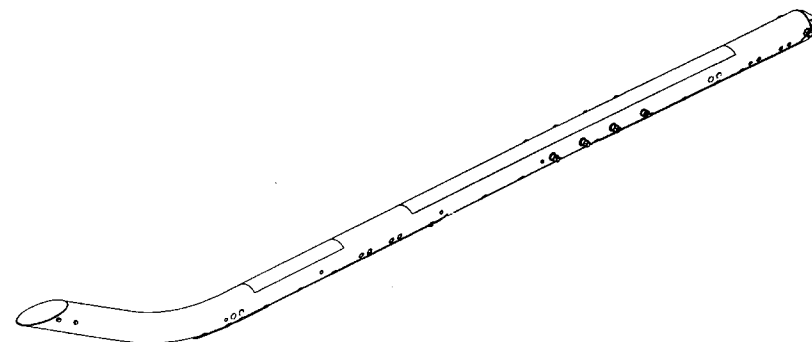
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

26256



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-09-22/1/11

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

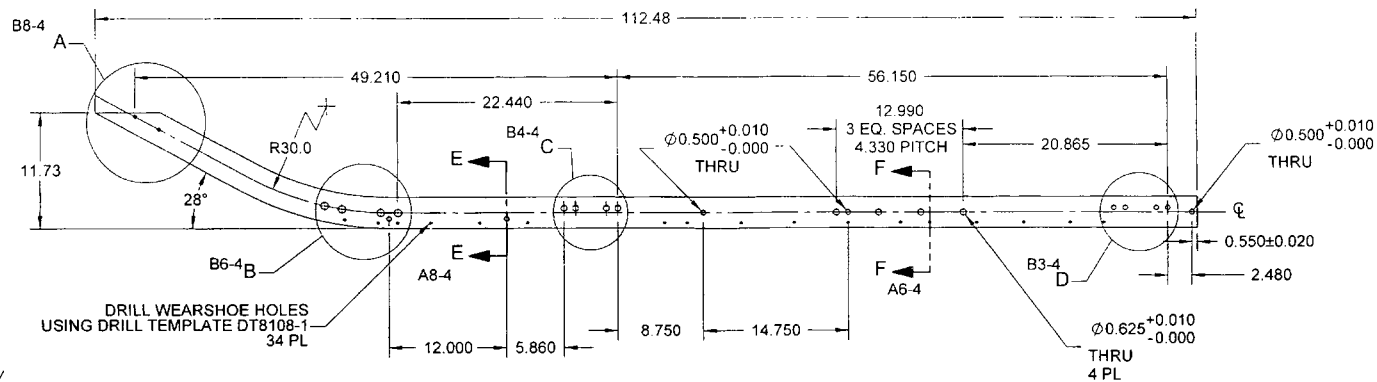
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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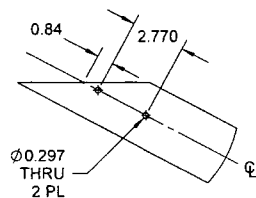
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

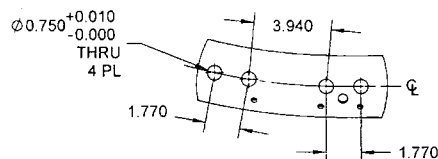
NOTE: Date & initial all entries



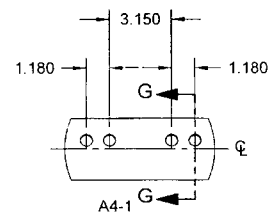
D2750-1 LH SKIDTUBE



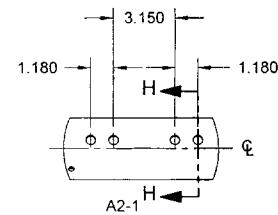
DETAIL A
SCALE 2X



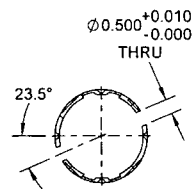
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SCALE 2X



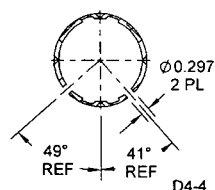
DETAIL C
SCALE 2X



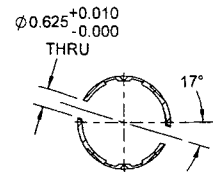
DETAIL D
SCALE 2X



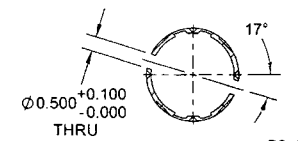
SECTION E-E
SCALE 3X, 2 PL





SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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86256

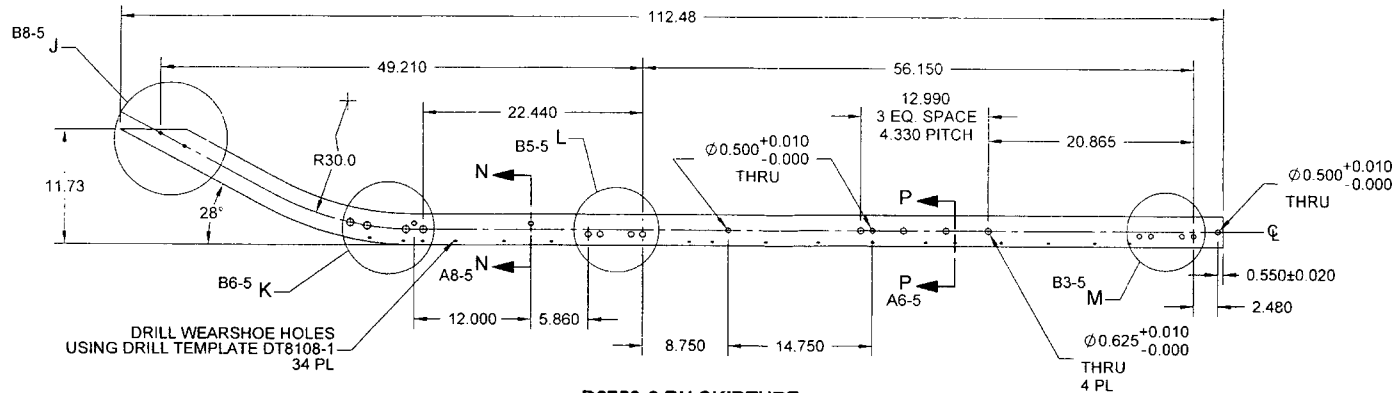
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

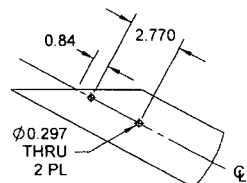
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

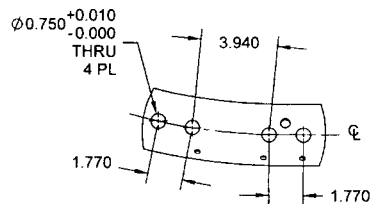
NOTE: Date & initial all entries



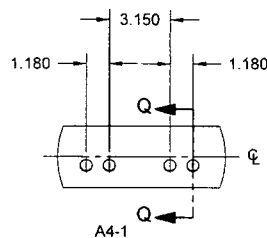
D2750-2 RH SKIDTUBE



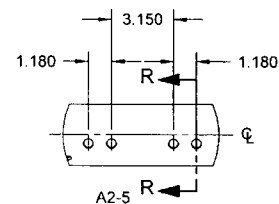
DETAIL J
SCALE 2X



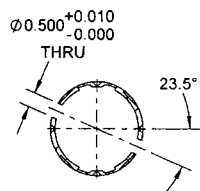
DETAIL K
SCALE 2X



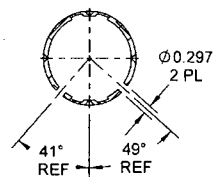
DETAIL L
SCALE 2X



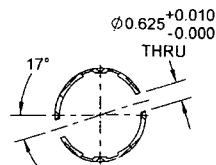
DETAIL M
SCALE 2X



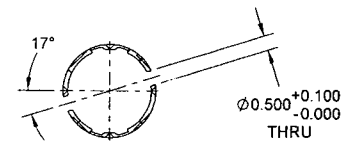
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED	REV	DRAWING NO. D2750	REV. F
MFG. APPR.	REV	TITLE	SHEET 5 OF 11
APPROVED	REV	350 SKIDTUBE ASSEMBLY	
DE APPR.	REV	SCALE	
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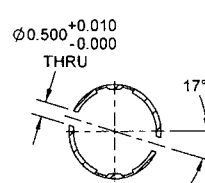
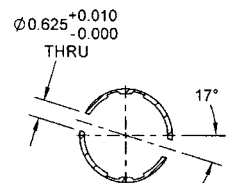
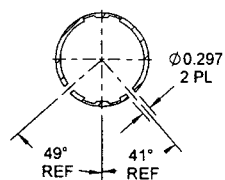
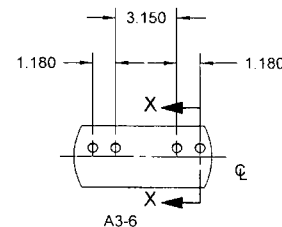
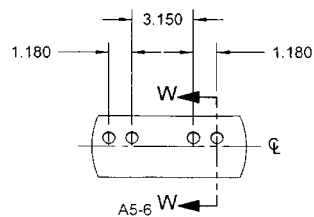
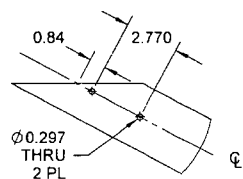
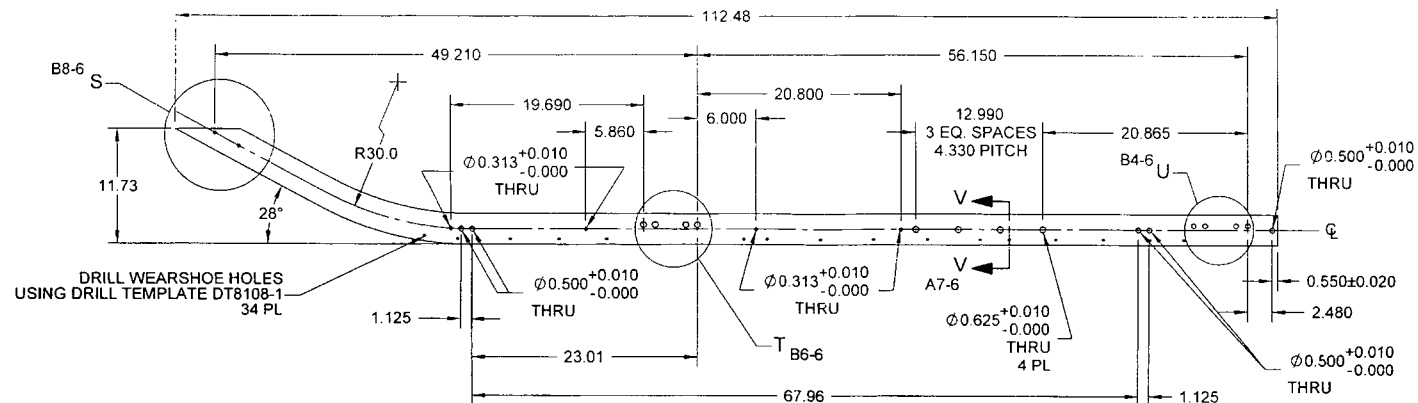
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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08-07-16

DESIGN		DART AEROSPACE USA, INC.
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CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. F
APPROVED		SHEET 6 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

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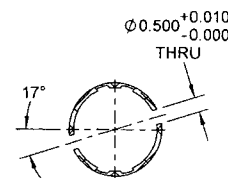
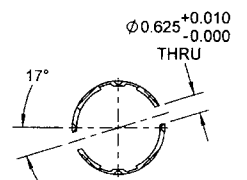
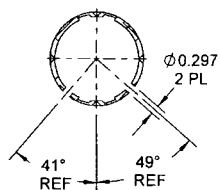
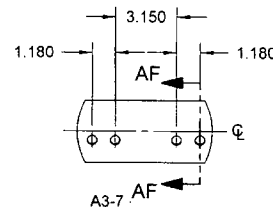
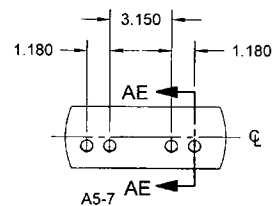
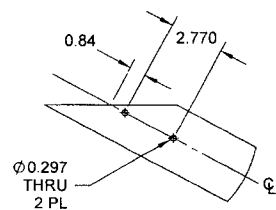
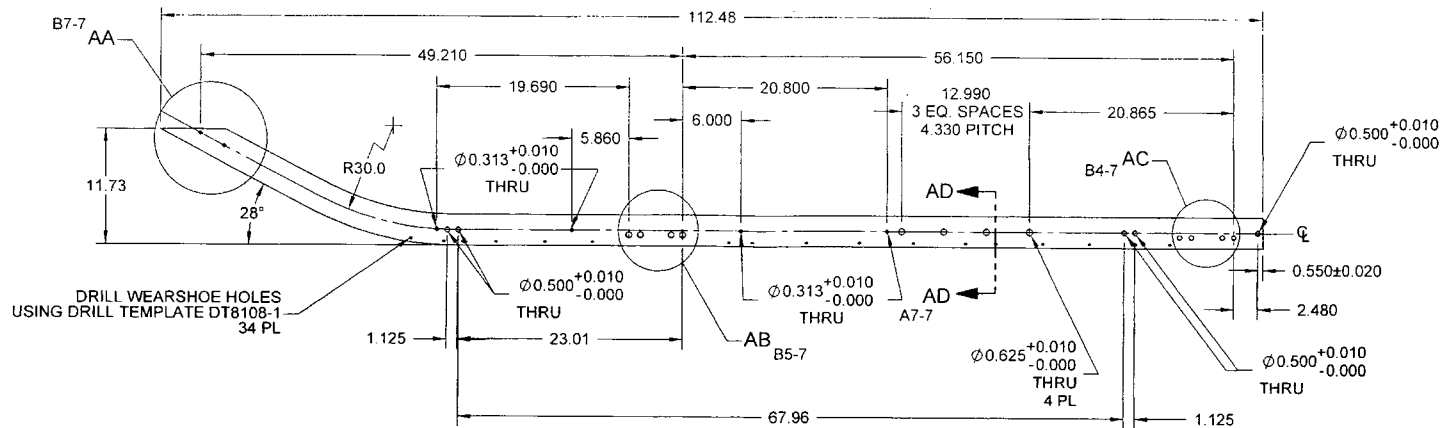
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DESIGN		DART AEROSPACE USA, INC.
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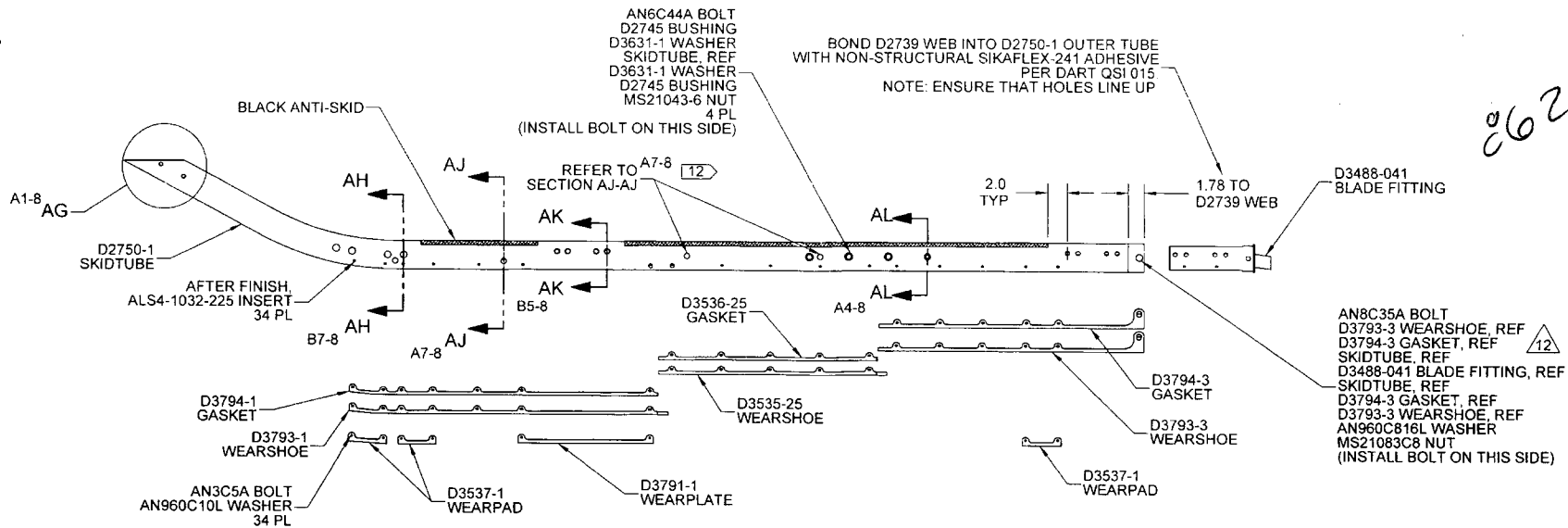
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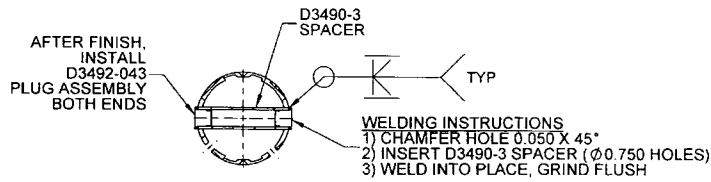
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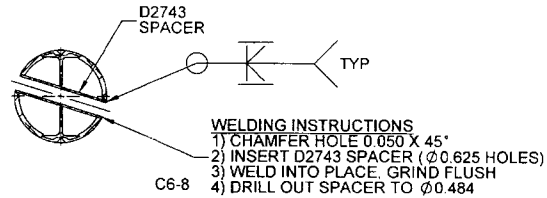
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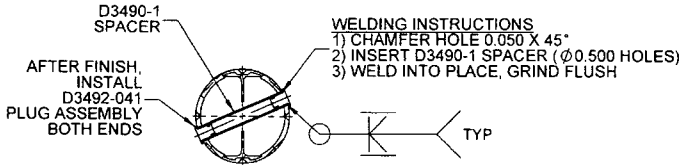
D2750-041 350 SKIDTUBE ASSEMBLY, LH



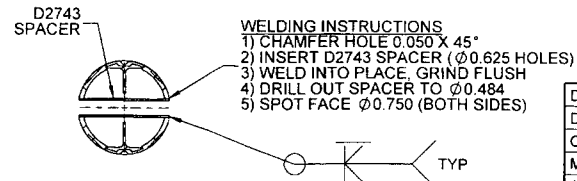
SECTION AH-AH
SCALE 3X, 4 PL



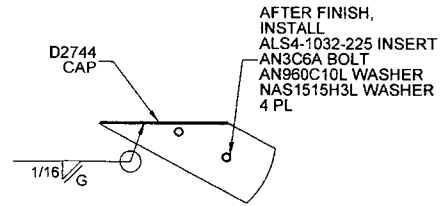
SECTION AK-AK
SCALE 3X, 4 PL



SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AG
SCALE 2X

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DESIGN	BY	DART AEROSPACE USA, INC.
DRAWN	BY	PORT HADLOCK, WA
CHECKED	BY	DRAWING NO. D2750
MFG. APPR.	BY	REV. F
APPROVED	BY	SHEET 8 OF 11
DE APPR.	BY	TITLE SCALE
DATE	08.07.16	350 SKIDTUBE ASSEMBLY NTS

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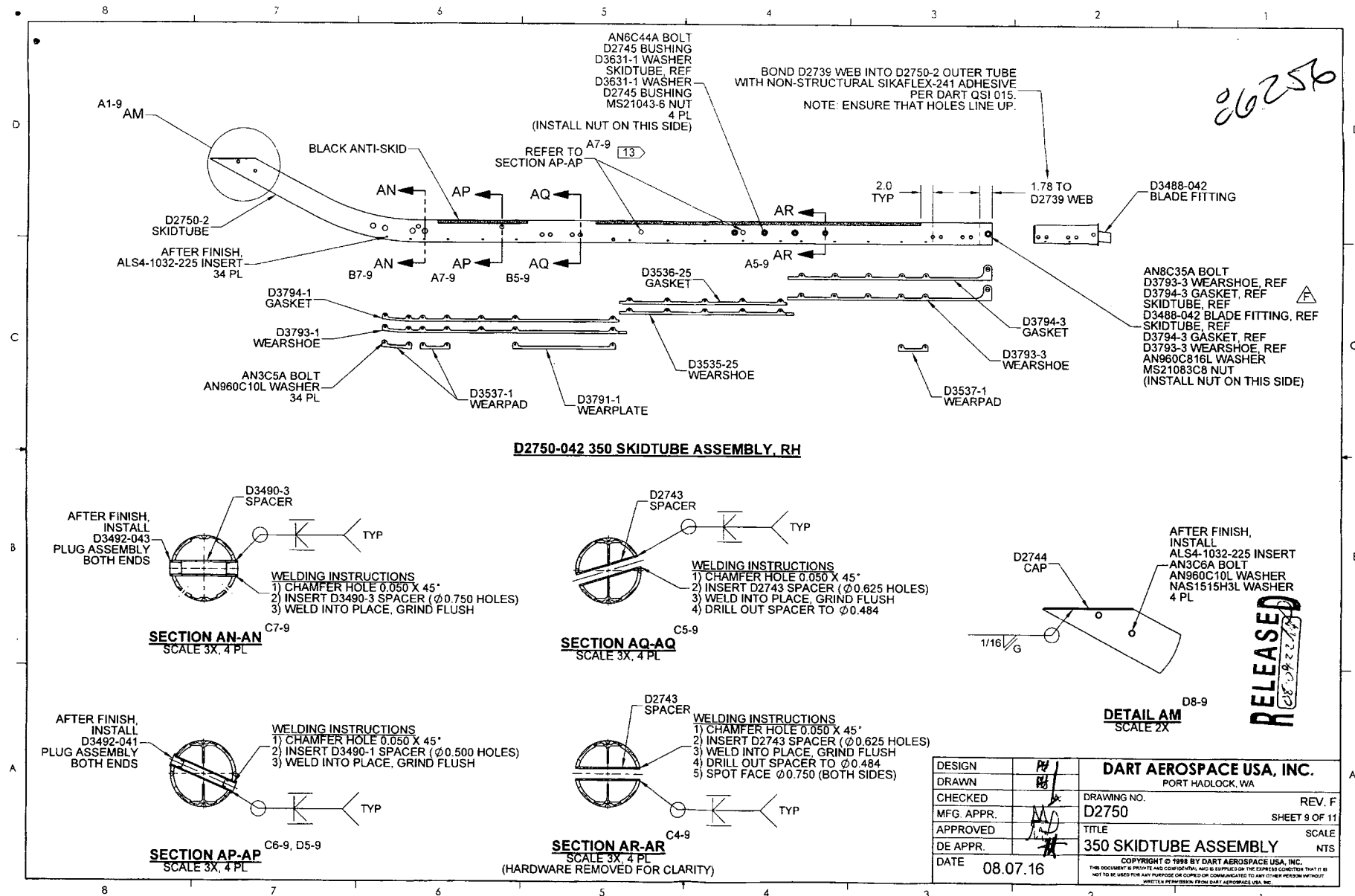
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

A1-10

AS

BLACK ANTI-SKID

A4-10

REFER TO
SECTION AW-AWAN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL

(INSTALL BOLT ON THIS SIDE)

AT

AU

AV

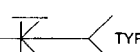
2.0
TYP1.78 TO
D2739 WEBBOND D2739 WEB INTO D2750-3 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.D3488-041
BLADE FITTINGD2750-3
SKIDTUBEAFTER FINISH,
ALS4-1032-225 INSERT
34 PLREFER TO
SECTION AU-AU

B7-10

A7-10

B4-10

A4-10

D3794-1
GASKETD3536-25
GASKETD3794-3
GASKETD3793-1
WEARSHOED3535-25
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AN960C10L WASHER
34 PLD3537-1
WEARPADD3791-1
WEARPLATED3537-1
WEARPADAN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-041 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL BOLT ON THIS SIDE)**D2750-043 350 SKIDTUBE ASSEMBLY, LH**D2743
SPACER

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484

SECTION AT-AT
SCALE 3X, 4 PL

D6-10

WELDING INSTRUCTIONS

1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)

D2743
SPACER**SECTION AV-AV**SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

D4-10

D2744
CAPAFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

1/16" G

DETAIL AS
SCALE 2X

D8-10

AFTER FINISH,
INSTALL
D3492-045
PLUG ASSEMBLY
BOTH ENDSD3490-5
SPACER

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AU-AU
SCALE 3X, 4 PL

D5-10, D6-10

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDSD3490-1
SPACER

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AW-AW
SCALE 3X, 4 PL

D4-10, D7-10

DESIGN	AS
DRAWN	AS
CHECKED	AS
MFG. APPR.	AS
APPROVED	AS
DE APPR.	AS
DATE	08.07.16

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO.
D2750

REV. F

SHEET 10 OF 11

TITLE
350 SKIDTUBE ASSEMBLY

SCALE

NTS

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2015-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

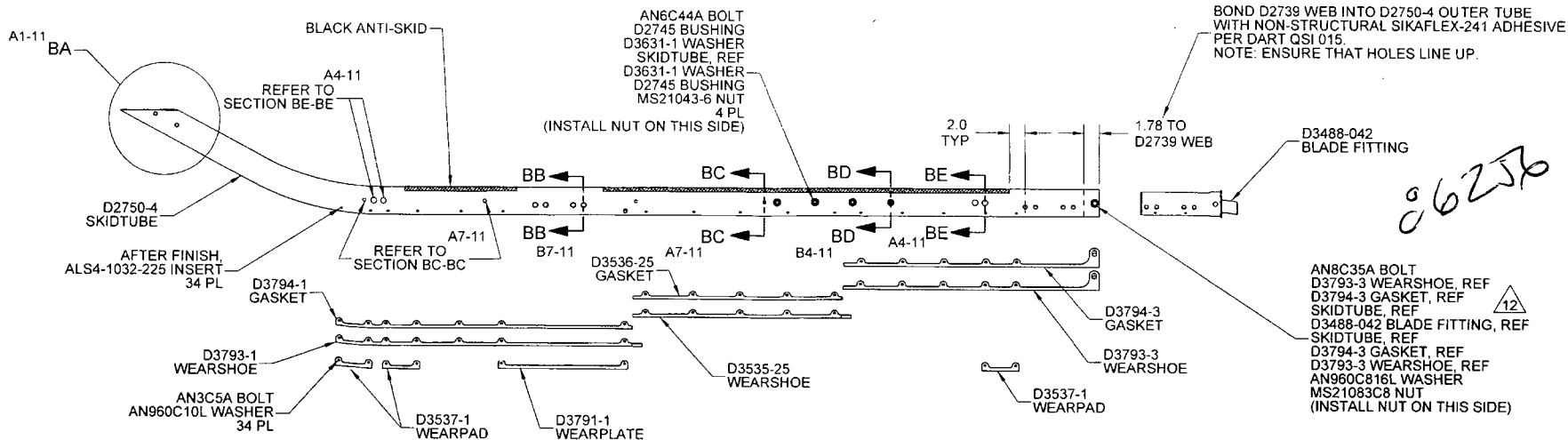
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

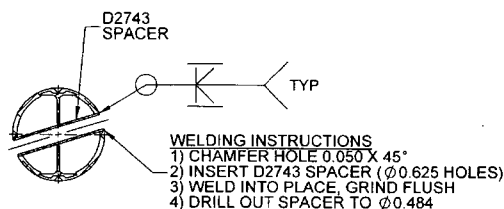
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

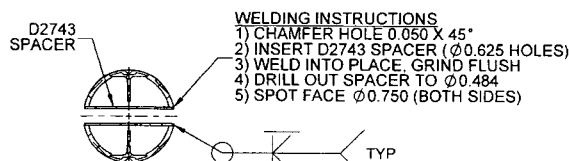
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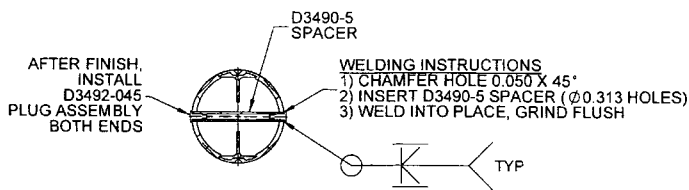
D2750-044 350 SKIDTUBE ASSEMBLY, RH



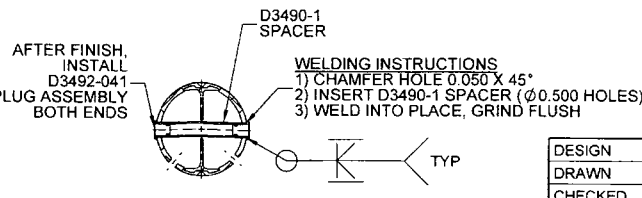
SECTION BB-BB
SCALE 3X, 4 PL



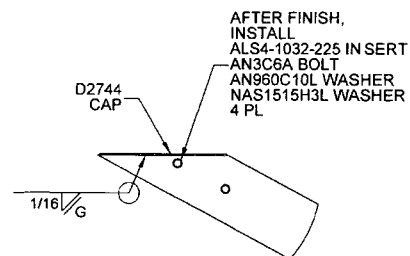
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN		DART AEROSPACE USA, INC.
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. F
APPROVED		SHEET 11 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

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RELEASED
08-07-22 1117

06250

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 298

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job #: 87012
Part #: A350-636-014
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum. in.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Penetration:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Fusion:	pass[<input checked="" type="checkbox"/>]	fail[]
Cracks:	pass[<input checked="" type="checkbox"/>]	fail[]
Overlap (cold lap)	pass[<input checked="" type="checkbox"/>]	fail[]
Undercut:	pass[<input checked="" type="checkbox"/>]	fail[]
Pin holes:	pass[<input checked="" type="checkbox"/>]	fail[]
Porosity (surface):	pass[<input checked="" type="checkbox"/>]	fail[]
Coloration:	pass[<input checked="" type="checkbox"/>]	fail[]
Burn through:	pass[<input checked="" type="checkbox"/>]	fail[]

Qualifier David Reed Date of Test Coupon 12.07.23
Welder Barclay Elliott Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld